

Work Order ID 81672

March-16-12 1:57:28 PM

\*81672\*

Page 1

Ship March 22

Item ID: D407-802-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Crew Door Opener Installation, LH

Start Date: 16/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/16 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100

0.00

\*100\*

DOCUMENT CONTROL

sl

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-011 CHG001

Schutz

MLJ 12/03/16

105

Pick Kit

0.00

\*105\*

Packaging

Memo

0.00

Packaging

12/3/19 SPD

110

QC4- 100% Inspect kits for completeness

0.00

\*110\*

QC

Memo

0.00

Quality Control

Schutz

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81672

**\*81672\***

Page 2

March-16-12 1:57:28 PM

Item ID: D407-802-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crew Door Opener Installation, LH

Start Date: 16/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-011								
	Location: <u>11</u>								
	PPP rev: <u>11</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

12 12/4/27

MLJ 12/04/27

12/04/27

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 1:57:32 PM

Page 1

Work Order ID: 81672

\*81672\*

Parent Item: D407-802-011

\*D407-802-011\*

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC  
10.12.02 per revA DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-15

\*D3552-15\*

Door Prop

Manufactured No

105 Each 18.0000 1

\*\*

Location

Loc Qty

Loc Code

ST272

18

65119

1

79271

11

80346

6

D3622-5

\*D3622-5\*

Ball Stud

Manufactured No

105 Each 24.0000 2

\*\*

Location

Loc Qty

Loc Code

ST058

24

76963

4

80406

20

D4106-1

\*D4106-1\*

Sill Douber, LH

Manufactured No

105 Each 0.0000 1

\*\*

D4106-3

\*D4106-3\*

Crew Door Douber, LH

Manufactured No

105 Each 9.0000 1

\*\*

Location

Loc Qty

Loc Code

ST127

9

79342

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 1:57:32 PM

Page 2

Work Order ID: 81672

\*81672\*

Parent Item: D407-802-011

\*D407-802-011\*

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4106-5

Manufactured No

105

Each

2.0000

1

1

\*D4106-5\*

Spacer, Sill Doublber

\*\*

D4106-7

Manufactured No

105

Each

9.0000

1

1

\*D4106-7\*

Template

\*\*

CR3523-4-02

Purchased No

105

Each

657.0000

26

26

\*CR3523-4-02\*

RIVET

\*\*

CR3523-4-4

Purchased No

105

Each

68.0000

4

4

\*CR3523-4-4\*

Rivet

\*\*

## Location

ST127

64341

## Loc Qty

2

2

## Loc Code

## Location

ST127

76460

79172

## Loc Qty

9

3

6

## Loc Code

## Location

ST332

116391

116893

116915

117978

120308

120422

120873

## Loc Qty

657

100

3

1

38

100

15

400

## Loc Code

## Location

ST332

119717

## Loc Qty

68

68

## Loc Code

March-16-12 1:57:32 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 3

March-16-12 1:57:32 PM

Work Order ID: 81672

\*81672\*

Parent Item: D407-802-011

\*D407-802-011\*

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-5

Purchased

No

105

Each

50.0000

3

3

\*CR3523-4-5\*

Rivet

\*\*

## Location

## Loc Qty

## Loc Code

ST332

50

117423

50

CR3523-4-6

Purchased

No

105

Each

128.0000

8

8

\*CR3523-4-6\*

Rivet

\*\*

## Location

## Loc Qty

## Loc Code

ST314

28

116606

28

ST332

100

120422

100

CR3523-4-07

Purchased

No

105

Each

47.0000

7

7

\*CR3523-4-07\*

RIVET

\*\*

## Location

## Loc Qty

## Loc Code

ST332

47

116606

44

17768

3

MS20426AD4-5

Purchased

No

105

Each

5,032.000

4

4

\*MS20426AD4-5\*

Rivet

\*\*

## Location

## Loc Qty

## Loc Code

ST317

5032

6874

5032

March-16-12 1:57:32 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 1:57:32 PM

Page 4

Work Order ID: 81672

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

\*81672\*

\*D407-802-011\*

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

38.0000

2

\*MS21073L5\*

nut plate

\*\*

## Location

## Loc Qty

## Loc Code

ST302

28

117395

28

ST303

10

120986

10

NAS1149C0532R

Purchased

No

105

Each

485.0000

6

\*NAS1149C0532R\*

WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST297

485

116373

1

116513

53

118384

31

119736

400

NAS1149C0563R

Purchased

No

105

Each

422.0000

6

\*NAS1149C0563R\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST296

200

120422

200

ST297

222

116391

22

117460

200

March-16-12 1:57:32 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

## 5.1 D407-802-011/-012 Crew Door Opener Kits

Qty -011	Qty -012	Part Number	Description
		D407-802-011	CREW DOOR OPENER KIT, LH
		D407-802-012	CREW DOOR OPENER KIT, RH
/ 1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
/ 1		D4106-1	SILL DOUBLER, LH
	1	D4106-2	SILL DOUBLER, RH
/ 1		D4106-3	CREW DOOR DOUBLER, LH
	1	D4106-4	CREW DOOR DOUBLER, RH
/ 1	1	D4106-5	SPACER, SILL DOUBLER
/ 1	1	D4106-7	TEMPLATE
26	26	CR3523-4-2	RIVET
4	4	CR3523-4-4	RIVET
/ 3	3	CR3523-4-5	RIVET
8	8	CR3523-4-6	RIVET
7	7	CR3523-4-7	RIVET
4	4	MS20426AD4-5	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER